

Work Order ID 86046

June-19-12 4:10:29 PM

86046

Page 1

Item ID: D3929-042

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gusset Assembly

Start Date: 19/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/2012 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3929	A								
100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3929								
324.175	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

Jm 12-6-23

12-6-23

Jm 12-6-23

12-6-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00				2			12/06/24
Quality Control									
140		0.00							
140									
Large Fab	Memo	0.00							
Large Fab	Weld bushings D3907-1 as per dwg D3929								
	316L rod batch: <u>M121602</u>								
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
150									
QC	Memo	0.00							
Quality Control						27			12-06-27

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Setup Start *NS1*

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Item Name: Gusset Assembly

Stop *NS2*

Start Date: 19/06/2012 **Start Qty:** 2.00

2

Cust Item ID:**Required Date:** 03/07/2012 **Req'd Qty:** 2.00

2

Customer:

Reference:

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

170 Identify as per dwg & Stock Location: WA

0.00

170

Packaging

Memo

0.00

Packaging

180 QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

June-21-12 11:17:41 AM

Page 1

Work Order ID: 86046

86046

Parent Item: D3929-042

D3929-042

Parent Item Name: Gusset Assembly

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 2.00

Required Qty: 2.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S11GA

Purchased

No

100

sf

62.4260

0.45

0.947368

M304S11GA

304/316 0.125 Sheet

**

Jm 12-6-23

Location

Loc Qty

Loc Code

MAT020

62.426

121380

24.9

121780

37.526

121780

D3907-1

Manufactured

No

130

Each

39.0000

2

4

D3907-1

Bushing

**

CC 12-6-26

Location

Loc Qty

Loc Code

WA

39

82786

39

4

W/O:		WORK ORDER CHANGES					
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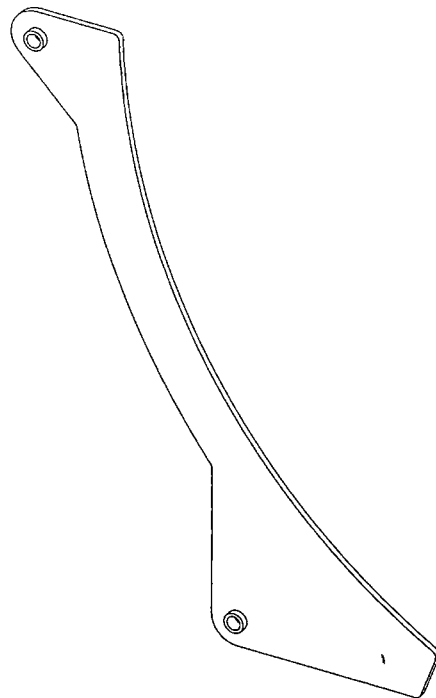
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

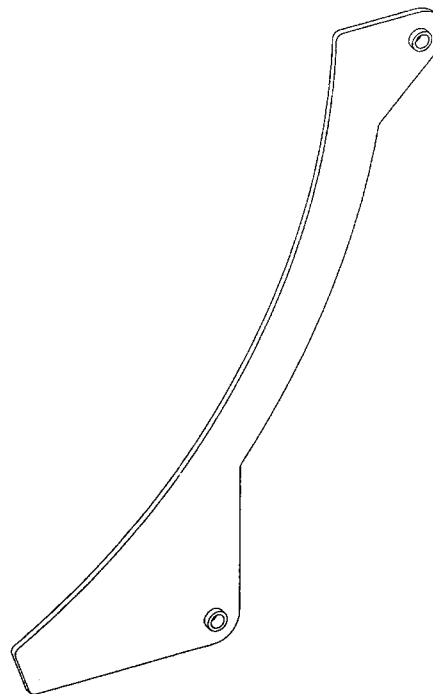
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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 80046 *MLJ*
12/06/20

RELEASED
8/24/12

A	NEW ISSUE		MB	09.04.03
REV.		DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.04.03			

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.73 lbs EACH
- 8) WELDING: PER DART QSI 004

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. **D3929**
REV. A
SHEET 1 OF 3
TITLE **GUSSET ASSEMBLY**
SCALE
NTS

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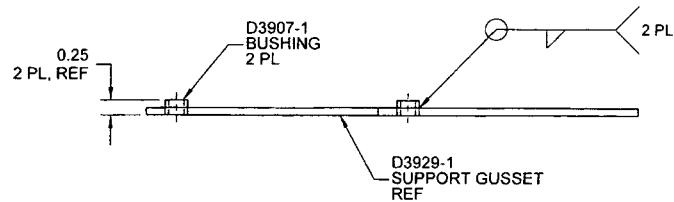
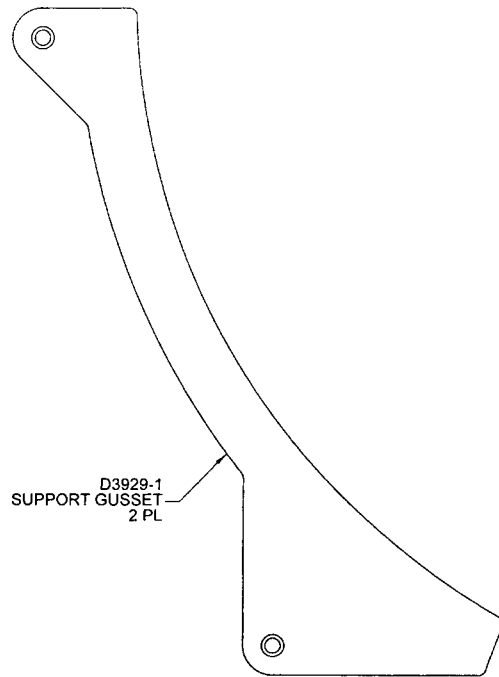
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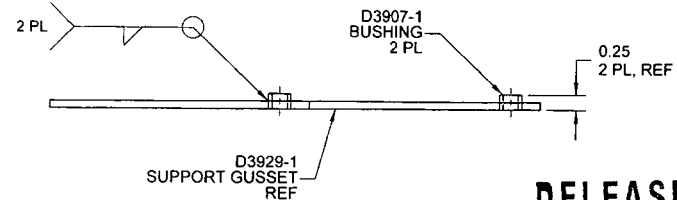
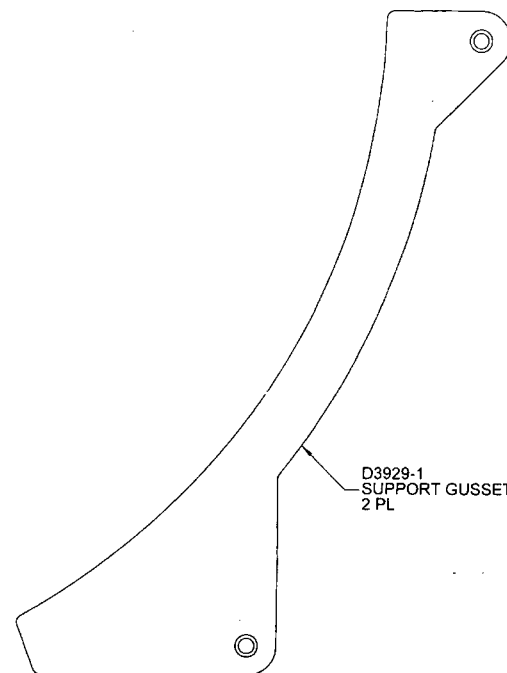
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NOTE: Date & initial all entries



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

RELEASED
09/04/22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3929	REV. A
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
DATE	09.04.03	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

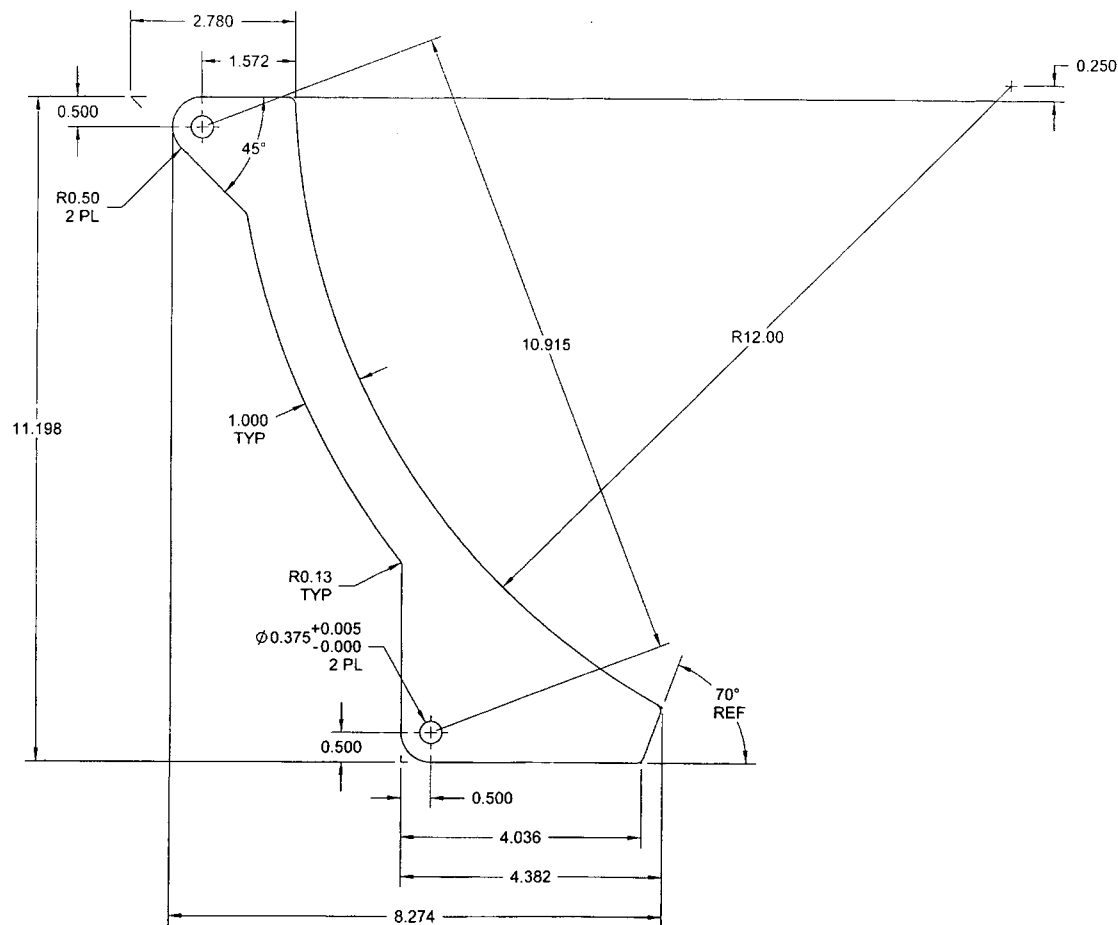
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D3929-1 SUPPORT GUSSET

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
11 GAUGE (0.125 THICK)
REF. DART SPEC. M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.72 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 3 OF 3
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8/24/22

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